

DART AEROSPACE LTD	Work Order:	23642
Description: Saddle Billet (6061)	Part Number:	D6102-011
04.09.09 4 09.09.09		
Dwg: D6102 Rev. B C	Qty:	3
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	U	05.06.21	3
2	PG	Issue P/O: <u>2008253</u> a) Description: Aluminum Billet b) 6.500" x 8.250" x 2.500" thick c) Tolerance on all dimensions is +0.06/0.00 d) Grain direction along 6.500" length e) Material: 6061-T6/T6511 (QQ-A-250/11 or QQ-A-200/8) Material release certificate is required	U	05.06.21	3
3	RG	Receive and Inspect for transit damage Ensure material release certificate is attached	DL	05/06/27	3
4	QC6	Inspect dimensions as per Dwg D6102 Check certificate to Dwg D6102 for compliance	RE	05.06.29	3
5	ST	Identify and Stock	RE	05.06.29	3
6	AC	Cost / part: <u>84.06</u>	SUR	05.06.30	3
7	DC	Close W/O <u>76.83</u> Inspect Level 21	4	05.07.04	3

Rev	Date	Change	Revised By	Approved
A	04.08.19	New issue	KJ/JLM	<i>[Signature]</i>

RELEASED
[Signature] 04.08.19

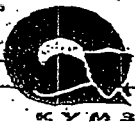
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



INSPECTION CERTIFICATE № 05.4850

EN 10204 - 3.1.B.



Consigner: Kamensk Uralsky Metallurgical Works, JSC., 5, Zavodskaya St., Kamensk Uralsky Sverdlovsk Region, 623405 Russia fax: (007) 3439-39-56-20			Shipping Date: 16.02.05 Plant Order №: 2358 Quantity: 2 Weight, kg.: 1960		
Consignee: Thyssen TMX Division			Specification №: N5568 Lot №: 1 Package №: 200488		
Contract number N5568-S CA8677/ 090129-8 (V)			Our Order №:		
Description of Goods: Plates			Requirements on the Products:		
Temper of Alloy	Grade of Product	Dimensions, Inch/mm	Material conforms to quality of alloy: 6061 T651		
T651	-	2.5"X60.5"X144.5" 63.500X1536.7X3670.3	Product conforms to all requirements of: AMS 4027M AMS-QQ-A250/11F ASTM B209-04		

Mechanical Properties

The Condition of Tested Standards	Batch Number	Cast Number	Number of Tests	Tensile Strength		Yield Strength (0.2% offset)		Elongation, %		Hardness, HB
				ksi	ksi	ksi	ksi	min	max	
				min	max	min	max	min	max	
Required				42.0	-	35.0	-	6.0	-	-
-	61629	12-3733	2	47.0	47.0	41.0	42.0	11.0	11.8	-

Chemical Composition, %

Element	Silicon Si	Iron Fe	Copper Cu	Manganese Mn	Magnesium Mg	Chromium Cr	Nickel Ni	Zinc Zn	Titanium Ti	Zirconium Zr
Required	0.40-0.80	0.700	0.15-0.40	0.15	0.80-1.20	0.04-0.35	-	0.25	0.15	-
Contents	0.64	0.200	0.20	0.03	1.00	0.05	-	0.04	0.07	-

Element	Ti+Zr	Na	Tin Sn	Bismuth Bi	Plumbum Pb	Mn+Cr	Ca	Other Elements		Al
								Each	Total	
Required	-	-	-	-	-	-	-	0.05	0.15	remainder
Contents	-	-	-	-	-	-	-	0.05	0.15	remainder

Other Tests

Method	Macro-structure	Micro-structure	USI	Electro-conductivity	Contents H2 of metals cm3/100gr
Result	-	-	-	-	-

On behalf:

Date:

Inspector:

Inspection Department engineer

KUMW, JSC

16.02.05

I. N. Strahova

N.V. Alekhina

Mercury - Free

CERTIFICATION

SOLD TO:

DATE:

CUSTOMER P.O.:

CUSTOMER PN.:

ATTN:

QUANTITY:

BY:

THYSSEN COPPER & BRASS SALES INC.

MAY 12 2005

